

Date: Friday, 25/04/2008 11:38:55 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MIRROR ARM		
Job Number	: 38796			Part Number	: D2010104		
Estimate Number	: 10335			Drawing Number	: D2010 REV. C2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/04/2008 S.O. No. :			Drawing Revision	: C2		
Prsht Rev.	: NC			Material	:		
First Issue	: 25/04/2008 Type : SMALL /MED FAB			Due Date	: 05/05/2008 Qty: 10 Um: Each		
Previous Run	: 37722						
Written By	:						
Checked & Approved By	: <u>JUL 08. 4.25</u>						
Comment	: Est A 04.02.17 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.5750 f(s)/Unit Total : 15.7500 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035)	Batch No: <u>M 107166</u> <u>SP 08/04/2008</u>
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104	<u>SP 08/04/2008</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr	<u>FF 08-05-01</u>
4.0	D2057	Plug	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Plug Batch No: <u>B 34366</u>	<u>FF 08-05-01</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010	<u>FF 08-05-01</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MIRROR ARM

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5080501 X10

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



11100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

11:50 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:20 pm

AS

08-05-01

X10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M/L

08/05/01

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST288

AS 08/05/01 X10

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



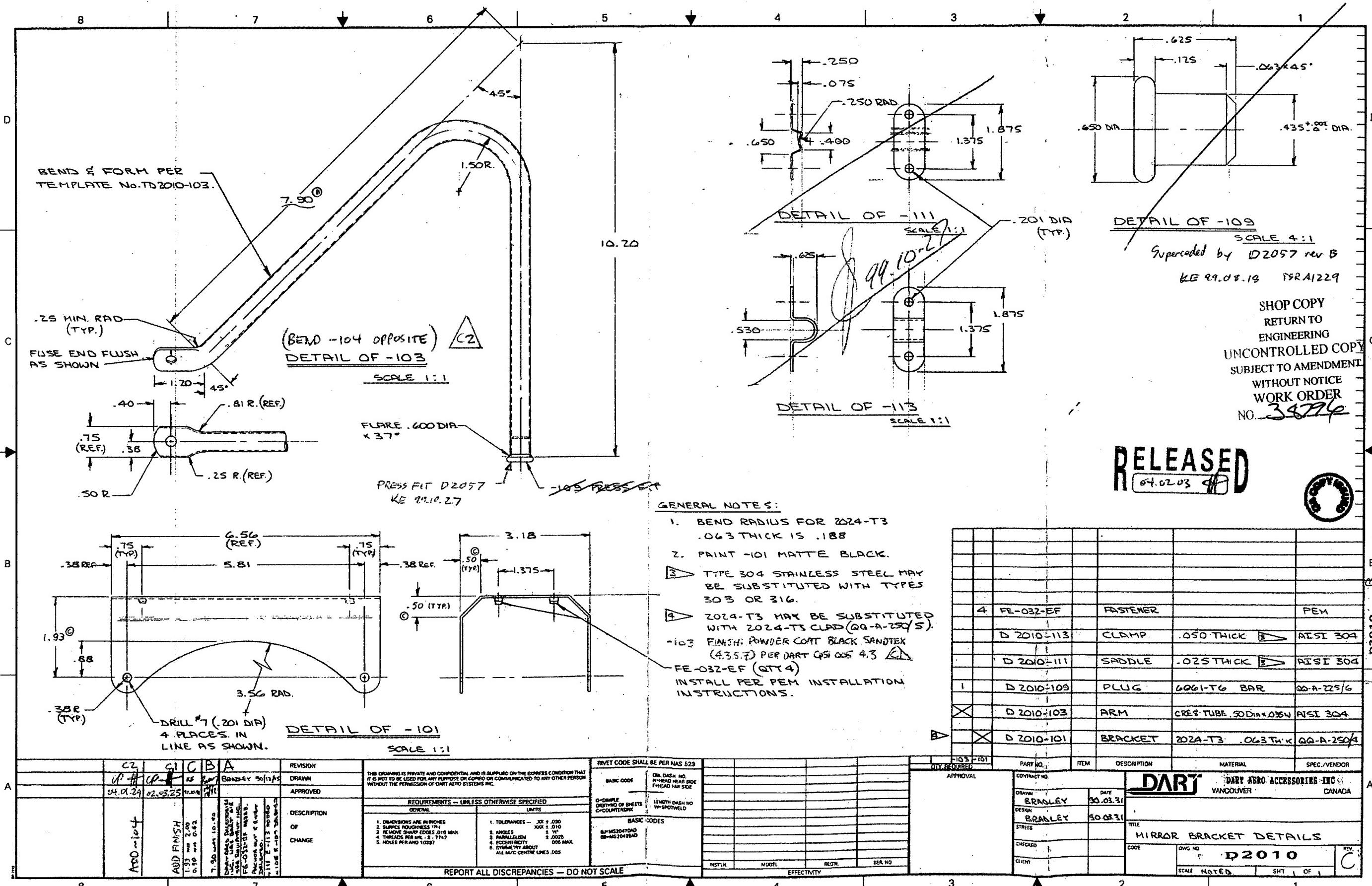
MF 08-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
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NO. 34746

SCALE 4:1

KE 99.08.18 TSR A1229

KE 99.08.13 ISR A1229

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WITHOUT NOTICE
WORK ORDER

RELEASER
04.02.03



PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
4	FE-032-EF	FASTENER		PEM		
	D 2010-113	CLAMP	.050 THICK		AISI 304	
	D 2010-111	SADDLE	.025 THICK		AISI 304	
1	D 2010-109	PLUG	6061-T6 BAR	QQ-A-225/6		
X	D 2010-103	ARM	CRES TUBE .50DIA x .035W	AISI 304		
X	D 2010-101	BRACKET	202A-T3 .063 THK	QQ-A-250/4		
F-103-101 COPY REQUIRED		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
APPROVAL		CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER		CANADA
		DRAWN BRADLEY	DATE 30.03.31			
		DESIGN BRADLEY	30.03.31	TITLE MIRROR BRACKET DETAILS		REV. C
		STRESS				
		CHECKED				
		CLIENT				
		CODE	DWG NO. D 2010			
SCALE NOTED	SHT 1 OF 1					

GENERAL NOTE

1. BEND RADIUS FOR 2024-T3
.063 THICK IS .188
 2. PAINT -101 MATTE BLACK.

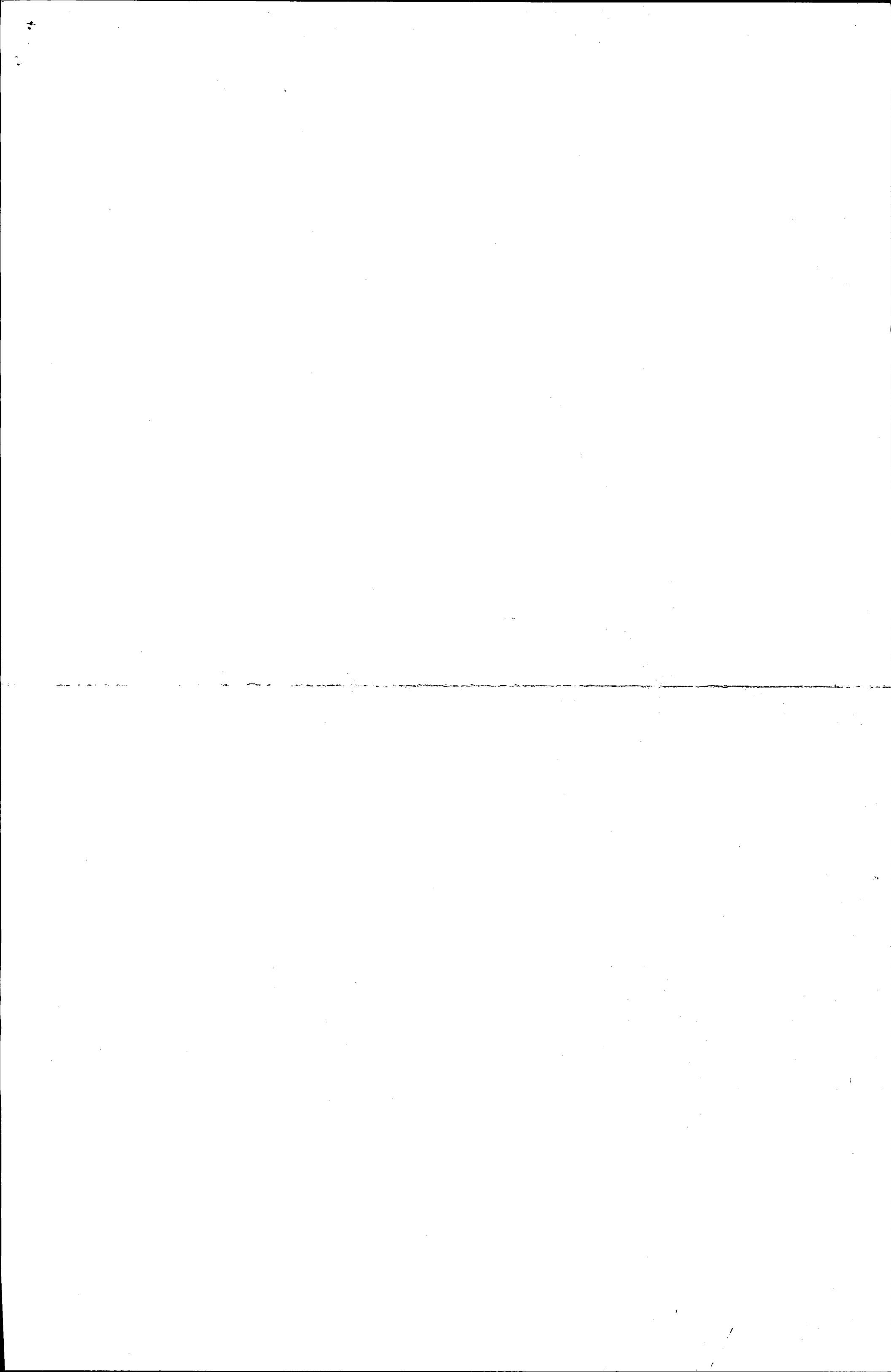
3 TYPE 304 STAINLESS STEEL MAY BE SUBSTITUTED WITH TYPES 303 OR 316.

4 2024-T3 MAY BE SUBSTITUTED WITH 2024-T3 CLAD (QQ-A-290) S

-103 FINISH: POWDER COAT BLACK SANTEX (4.35.7) PER DART QSI 005 4.3

FE-032-EF (QTY 4)

INSTALL PER PEM INSTALLATION INSTRUCTIONS.

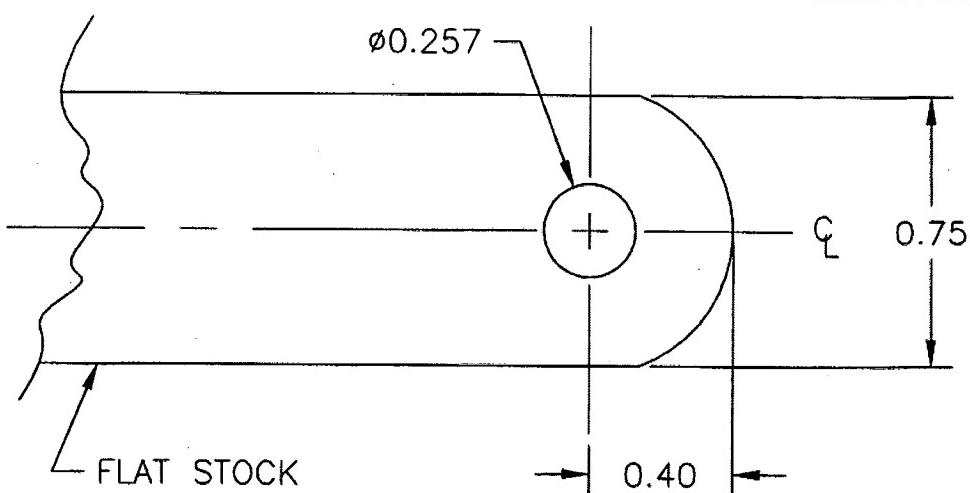
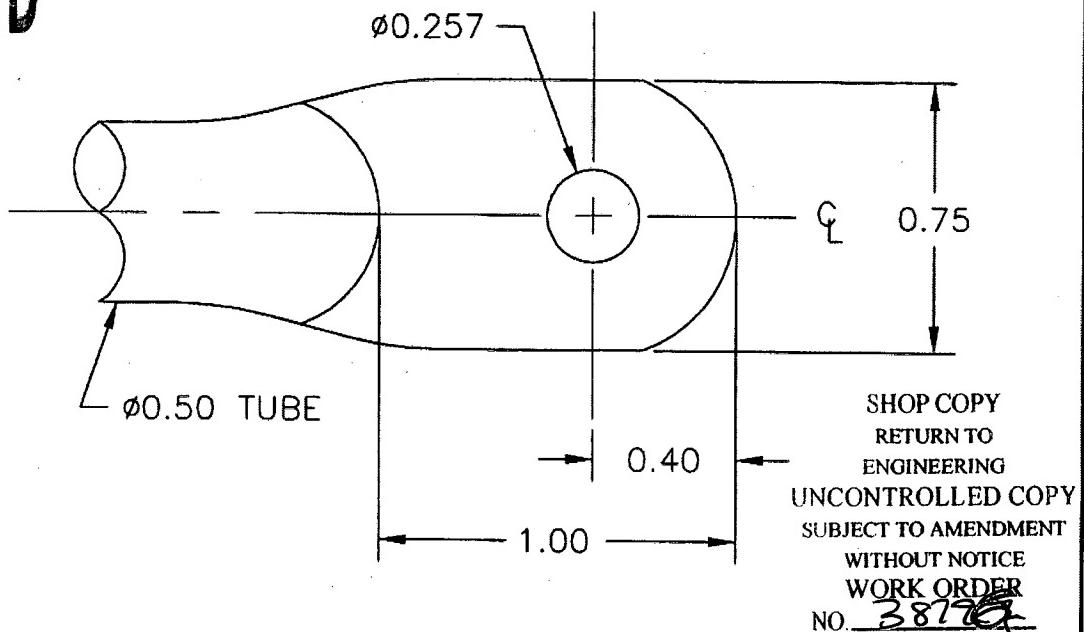


DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED <i>MW</i>	APPROVED <i>JA</i>	DRAWING NO. D2727	REV. A	SHEET 1 OF 1
DATE 97.11.24	TITLE PUNCH DT8012 SPEC CONTROL			SCALE 2:1
A	97.11.24	NEW ISSUE		
A1	<i>HCP</i> 01.12.20	ADD TOLERANCE NOTE		

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

